

Work Order ID 63811

Monday, November 15, 2010 8:36:22 AM

Page 1

Item ID: D412-630-033

Accept

Setup Start

Revision ID:

Item Name: Heli Access Step LH Folding

Stop

Start Date: 11/15/2010 Start Qty: 2.00

Required Date: 11/22/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

0.00

110

0.00



Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D412-630 p.14 ☐ Coat all hardware with LPS3 rust inhibitor ☐ A/R LPS3 batch: M109929 COAT exposed HARDWARE WITH LPS PROCYON ☐ A/R LPS PROCYON BATCH: M114596

0.00

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Pro →

cel for Bcr 11/01/03

E/S 11/01/04 (2)

(x2! 14)

Dart Aerospace Ltd

W/O: 63811		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/06	100	Perm. change Fix Route numbers to match correct ^{correct} sequence.	MA	11.01.06			S. W. B. O. C.

Part No: D412-630-033 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-630-033

Accept

Revision ID:

Item Name: Heli Access Step LH Folding

Start Date: 11/15/2010 Start Qty: 2.00

Required Date: 11/22/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/12/29.8

(2)

140

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

Salvador

12
LH

150

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-630-033

Location: _____
PPP Rev: A

11/15/10 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:

Stop

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Start Date: 11/15/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/22/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CK 11/01/06

MF
10-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 63811

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding



Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn 1019, added d2807-041 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107 Clevis		Manufactured	No			110	Each	28.0000	1	2		10/12/29sf	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST004				28					
				46634				2					
				62242				26					
D2803-041 Bracket Assembly		Manufactured	No			110	Each	5.0000	1	2		10/12/29sf	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST147				5					
				46639				4					
				61724				1					
D2804-041 Bracket Assembly		Manufactured	No			110	Each	1.0000	1	2		B 41674 10/12/29sf	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST150				1					
				46843				1					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Order ID: 63811

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

D2807-041

Manufactured No

110 Each

23.0000

2



Door prop

Location

Loc Qty

Loc Code

ST023

23

60540

2

60771

1

61891

20

10/12/29

D2813

Manufactured No

110 Each

35.0000

2



Washer

Location

Loc Qty

Loc Code

ST025

35

61051

35

10/12/29

D3562-041

Manufactured No

110 Each

1.0000

1



Step Assembly, LH

Location

Loc Qty

Loc Code

FG110

1

54963

1

64095

D3395-1

Manufactured No

110 Each

44.0000

4



Bushing

Location

Loc Qty

Loc Code

ST052

40

60861

40

ST055

4

46616

4

10/12/29

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 63811

Parent Item: D412-630-033


Parent Item Name: Heli Access Step L.H Folding

Start Date: 11/15/2010

Required Date: 11/22/2010


Start Qty: 2.00

Required Qty: 2.00

AN3C21A Purchased No 110 Each 56.0000 2 ⁴ 10/12/29 SP

 BOLT

Location Loc Qty Loc Code
 ST352 56


109148 56

AN8C16 Purchased No 110 Each 75.0000 2 ⁴ 10/12/29 SP

 Bolt

Location Loc Qty Loc Code
 ST345 75

105969 15


106066 60

AN310C8 Purchased No 110 Each 31.0000 2 ⁴ 10/12/29 SP

 Nut

Location Loc Qty Loc Code
 ST324 31

109148 1

111819 30

MS24665-302 Purchased No 110 Each 43.0000 6 ¹² 10/12/29 SP @ 20

 Cotter Pin

Location Loc Qty Loc Code
 ST309 43

113644 43

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 63811

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3

Purchased

No

110

Each

186.0000

4

8



Washer



10/12/298

Location

Loc Qty

Loc Code

ST277

186

111268

4

115675

82

115935

100

4

NAS1515H5L

Purchased

No

110

Each

140.0000

4

8



WASHER



10/12/298

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

100

108964

12

111359

88

8

NAS1515H8

Purchased

No

110

Each

322.0000

4

8



Washer



10/12/298

Location

Loc Qty

Loc Code

ST278

322

111275

122

111411

200

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 63811

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

110

Each

2,360.000

4

8



Nut



10/12/29 SF

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2284

112314

2284

MS24693-C280

Purchased

No

110

Each

49.0000

2



Screw



10/12/29 SF

Location

Loc Qty

Loc Code

ST310

30

115594

30

ST318

19

111279

19

D2806-1

Manufactured

No

140

Each

15.0000

2



Bushing



10/12/29 SF

Location

Loc Qty

Loc Code

ST025

15

46609

15

D2806-3

Manufactured

No

140

Each

15.0000

2



Bushing



10/12/29 SF 20

Location

Loc Qty

Loc Code

ST025

15

46737

15

4

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 6

Work Order ID: 63811

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

D28T0-5

Manufactured No

140 Each

6.0000



Strut



1 2

10/12/2958

Location

Loc Qty

Loc Code

ST265

6

52034

6

2

D3396-1

Manufactured No

140 Each

48.0000



Spacer



2

10/12/2958

Location

Loc Qty

Loc Code

ST055

48

46748

48

4

AN4C6A

Purchased No

140 Each

517.0000



Bolt



1 2

10/12/2958

20

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

513

113121

63

115016

200

116003

200

116075

50

2

Monday, November 15, 2010 8:36:26 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 63811

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

AN4C10A

Purchased No

140 Each

116.0000

1

2



Bolt



10/12/29sf

Location

Loc Qty

Loc Code

ST356

116

106302

5

111295

31

112243

50

114523

30

2

AN5C15A

Purchased No

140 Each

78.0000

2

4



Bolt



10/12/29sf

Location

Loc Qty

Loc Code

ST339

78

111819

78

140 Each

88.0000

1

2

AN44C7A

Purchased No



Eyebolt



10/12/29sf

Location

Loc Qty

Loc Code

ST362

88

109013

47

111308

40

111503

1

140 Each

167.0000

1

2

AN4C15A

Purchased No



Bolt



10/12/29sf

Location

Loc Qty

Loc Code

ST358

167

115835

67

115936

100

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Monday, November 15, 2010 8:36:26 AM

Page 8

Work Order ID: 63811

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Holding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1515H4

Purchased

No

140

Each

87.0000



Washer



14

10/12/29

Location

Loc Qty

Loc Code

ST277

87

111294

5

111525

82

NAS1515H5

Purchased

No

140

Each

212.0000



Washer



14

10/12/29

Location

Loc Qty

Loc Code

FG

44

103286

17

103691

27

ST277

168

109430

168

MS21043-4

Purchased

No

140

Each

774.0000



Nut



8

10/12/29 50 20

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

734

112492

25

113069

8

114523

101

114784

300

115936

300

Monday, November 15, 2010 8:36:26 AM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 63811



Parent Item: D412-630-033



Parent Item Name: Heli Access Step LH Folding

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS21043-5

Purchased

No

140

Each

568.0000

3

6



10/12/09 sf

(2)

672 Nut

Location

Loc Qty

Loc Code

ST301

568

111819

68

112314

500

4
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

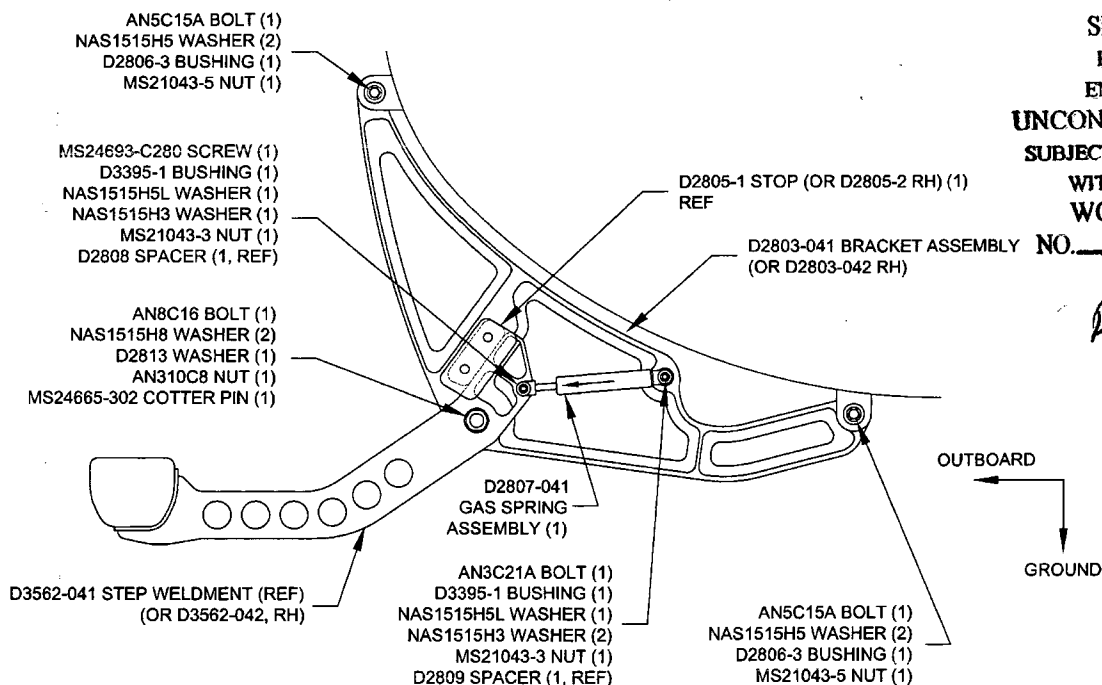
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation

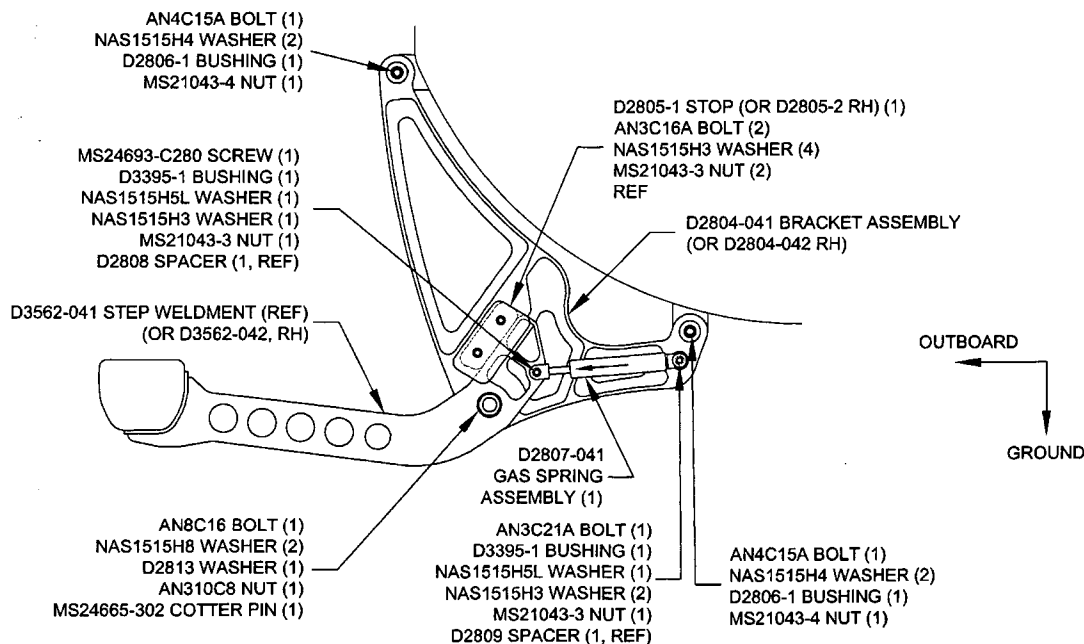


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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 43811

BP 10-11-15

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: M
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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Revision: M
Date: 08.12.12